

Work Order ID 61746

Page 1

Wednesday, September 01, 2010 11:40:02 A

Item ID:	D3651-043	Accept		Setup	Start				
Revision ID:									
Item Name:	Flange Weldment								
Start Date:	9/1/2010	Start Qty:	3.00		Cust Item ID:				
Required Date:	9/8/2010	Req'd Qty:	3.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:	<i>M</i>	Date: 10-9-01	Tooling:	Date:		Stop		
	QC:		Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100 	FLOW WATER JET Waterjet FLOW CNC Waterjet <i>304 .068</i>	0.00							<i>BB 10-11-4</i>
	Memo	0.00							
	1-Cut as per Dwg D3651 (D3651-7) <input type="checkbox"/> Dwg Rev: <i>S</i> <input type="checkbox"/> Prog Rev: <i>S</i> <input type="checkbox"/> 2-Deburr if necessary <input type="checkbox"/> IDENTIFY AS D3651-7								
110 	QC2- Inspect parts off machine FAI/FAIB QC Quality Control	0.00							<i>BB 10-11-4</i>
	Memo	0.00							
120 	QC8- Inspect parts - second check QC Quality Control	0.00	<i>S 10-11-4</i>						<i>(+4)</i> <i>(-7)</i>
	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61746

Wednesday, September 01, 2010 11:40:02 A



Page 2

Item ID: D3651-043

Accept



Setup Start



Revision ID:

Item Name: Flange Weldment

Stop



Start Date: 9/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



FLOW WATER JET

Waterjet

Memo

0.00

B10-11-4

FLOW CNC Waterjet

1-Cut as per Dwg D3651 (D3651-5) Dwg Rev: B Prog
Rev: B 2-Deburr if necessary Identify as D3651-5

140



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-11-4

QC

Quality Control

Memo

0.00

150



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

S101u108

(4)

>S

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Wednesday, September 01, 2010 11:40:02 A



Page 3

Item ID: D3651-043

Accept



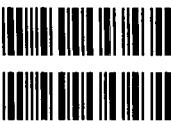
Setup Start



Revision ID:

Item Name: Flange Weldment

Stop



Start Date: 9/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

Form D3651-5 and D3651-7 as per Dwg D3651

SB 10/11/24

(4)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 -5 w/10s (+4.5's)

0.00 -5 w/10s (+4.7')

S.10w/10s

(X4)

180



Large Fab

Large Fab

Large Fab

Memo

Weld assembly as per dwg D3651

0.00

0.00

RPL 10.11.26

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Start Date: 9/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S10u129

(SAC)

210



Small Fab

Small Fab

Small Fab

0.00

0.00

=> m-k 10/12/13

(4X)

W/O:		WORK ORDER CHANGES					
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Page 5

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Start



Revision ID:

Item Name: Flange Weldment

Stop



Start Date: 9/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/01/12 45

0.00

(X4)

230



Packaging

Packaging

Identify as per dwg & Stock Location: 189

0.00

Memo

0.00

10/12/16 SP (6)

240



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/2016
ME
10-12-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, September 01, 2010 11:40:06 AM

Work Order ID: 61746



Parent Item: D3651-043



Parent Item Name: Flange Weldment

Start Date: 9/1/2010

Required Date: 9/8/2010

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Start Qty: 3.00

Required Qty: 3.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 01, 2010 11:40:06 AM

Page 2

Work Order ID: 61746



Parent Item: D3651-043



Parent Item Name: Flange Weldment

Start Date: 9/1/2010

Required Date: 9/8/2010

Start Qty: 3.00

Required Qty: 3.00

MS20427M3-3



Rivet

Purchased

No

210

Each

195.0000

16

48



m-f w/u/30

48 64

*

MS21060-3K



Nut Plate

Purchased

No

210

Each

154.0000

8

24



m-f w/u/30

64 32

*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST318	195	
115409	195	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST302	154	
109590✓	154	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Top Flange	Part Number:	D3651-5
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-11-4	Date: 10/11/08	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.10.07	New Issue	P/O D3651-043	KJ/DD  

DART AEROSPACE LTD	Work Order:	61746
Description: Bottom Flange	Part Number:	D3651-7
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 10-11-4	Date: 10/11/04	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	P/O D3651-043	KJ/DD  

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

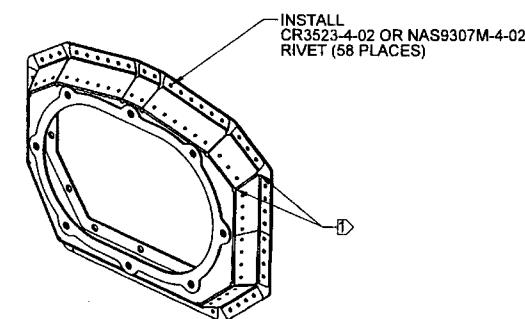
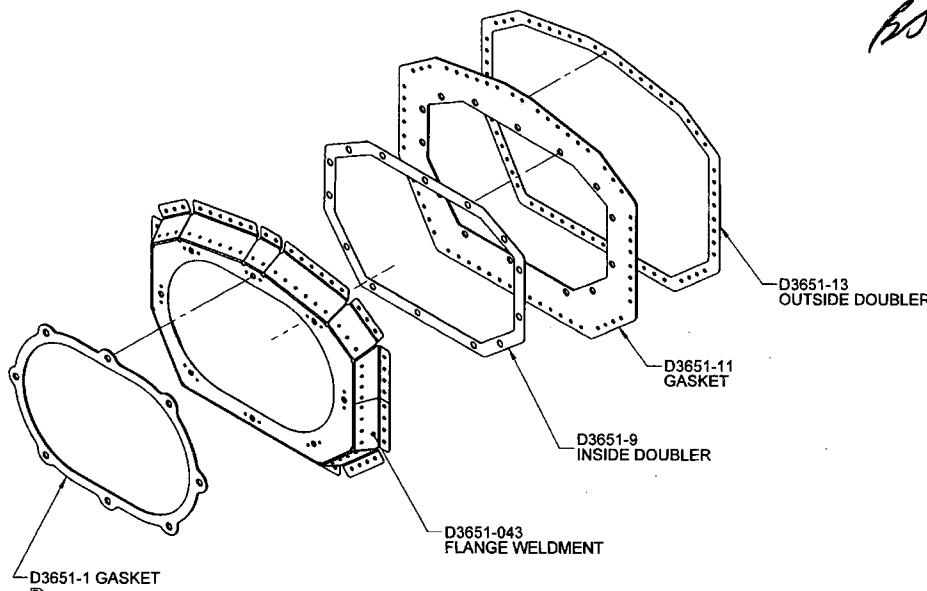
WITHOUT NOTICE

WORK ORDER

NO.

017446

b8r0-901



PART LIST

QTY	PART NUMBER	DESCRIPTION
-041	X D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

RELEASER
08-03-27-140

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9; GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	NA	D3651	SHEET 1 OF 9
APPROVED	RE	TITLE	SCALE
DE APPR.	RE	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY MATERIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED WITHOUT THE OTHER PERSON'S WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

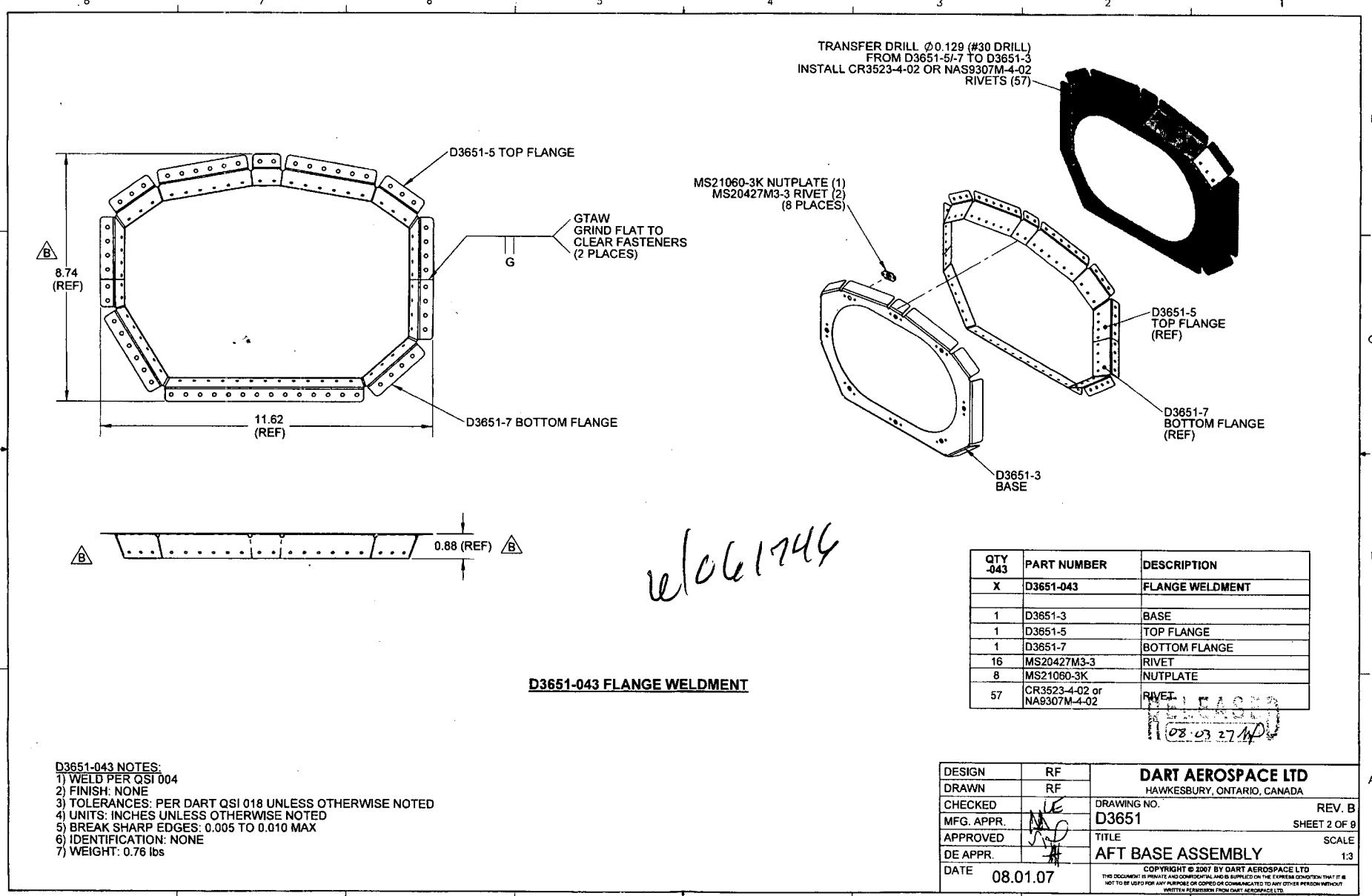
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



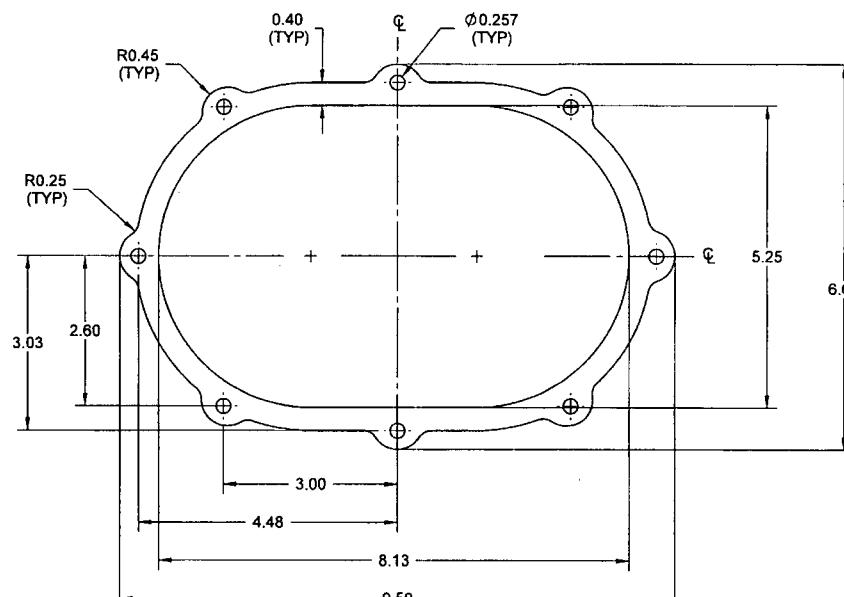
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NOTE: Date & initial all entries



wl6 41744

D3651-1 GASKET

NOTES:

- NOTES:**

 - 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) PART IS SYMMETRIC ABOUT $\frac{Q}{2}$
 - 8) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[initials]</i>	D3651	SHEET 3 OF 9	
APPROVED	<i>[initials]</i>	TITLE	SCALE	
DE APPR.	<i>[initials]</i>	AFT BASE ASSEMBLY	1:2	
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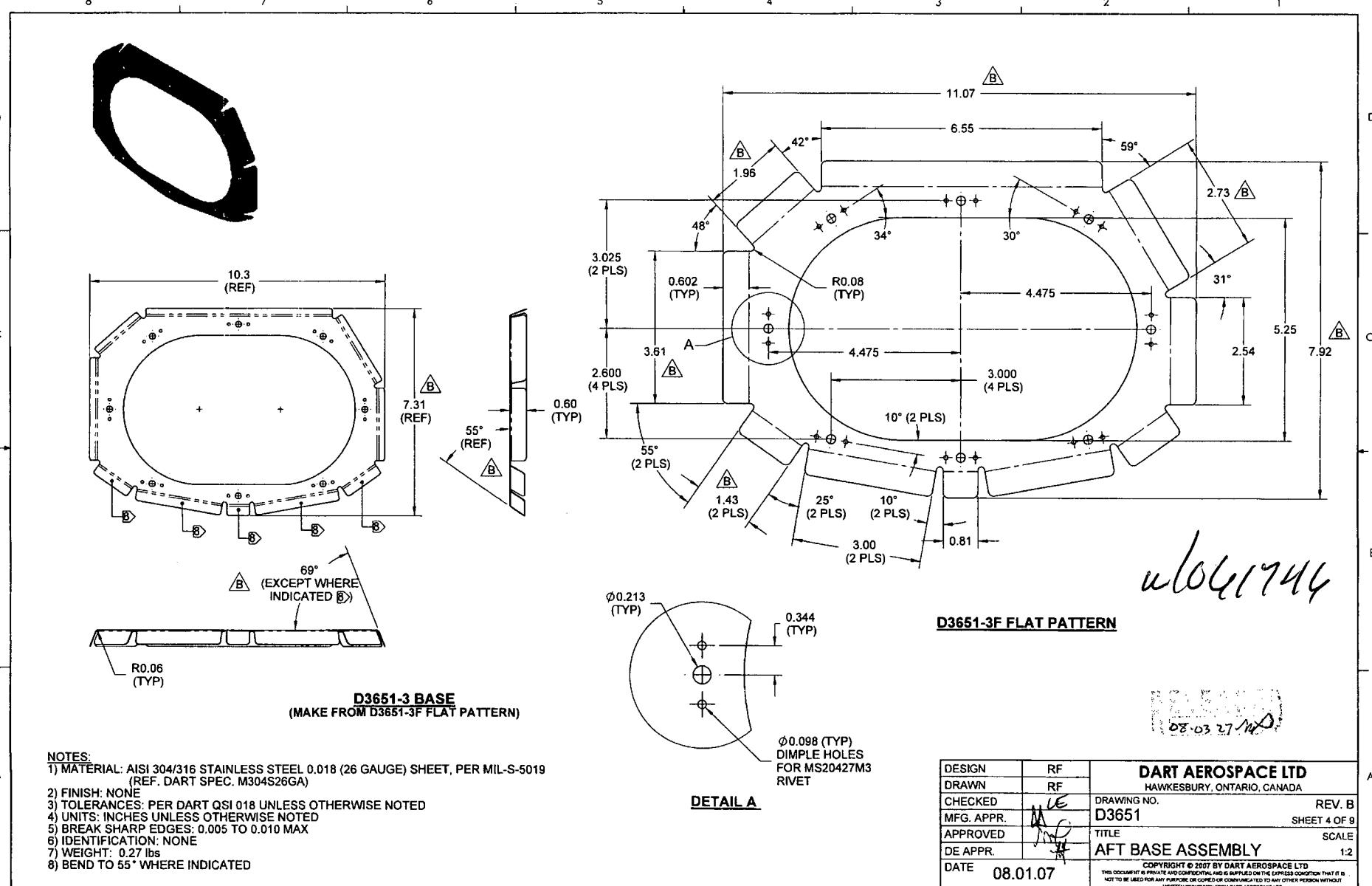
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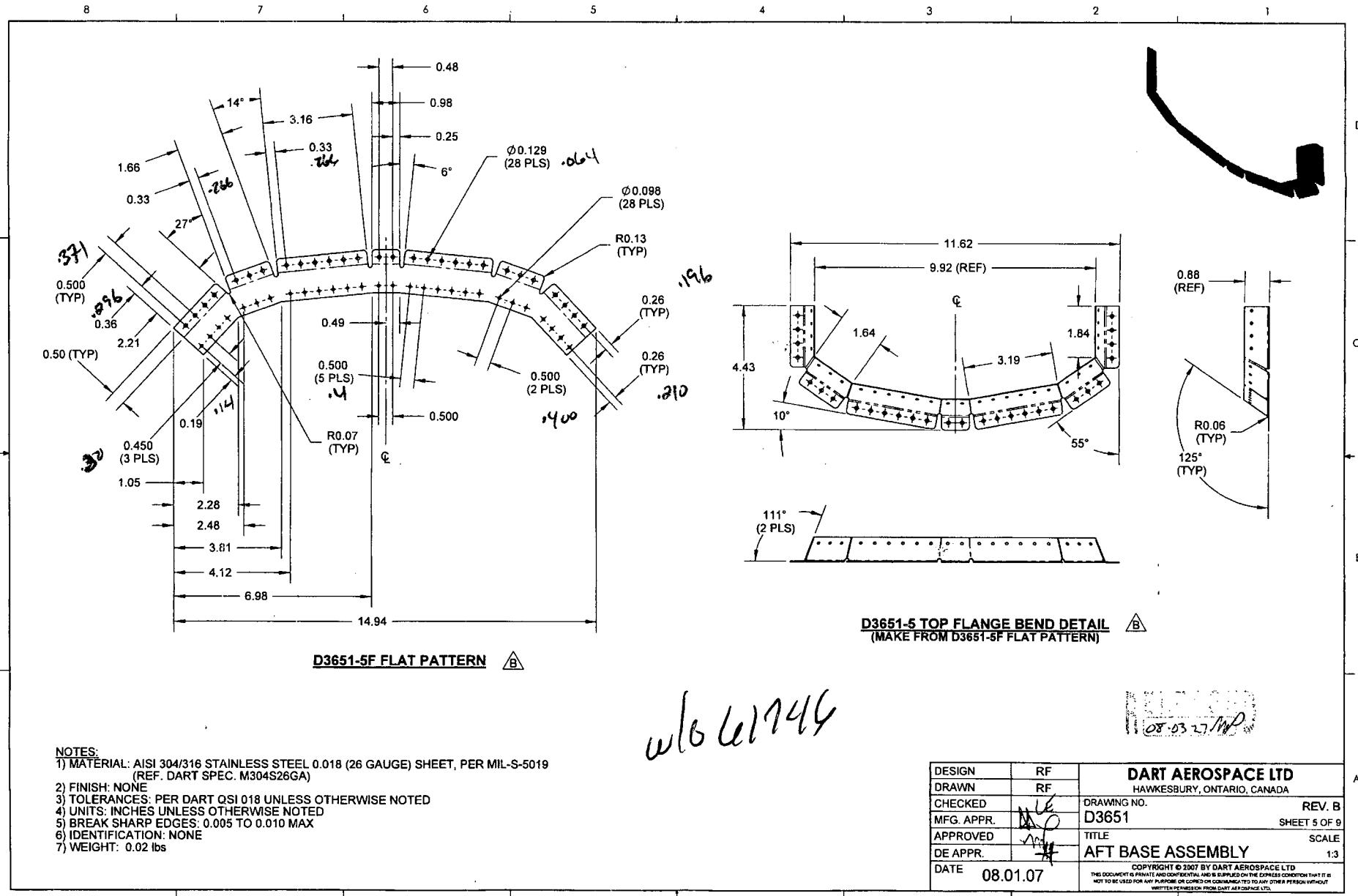
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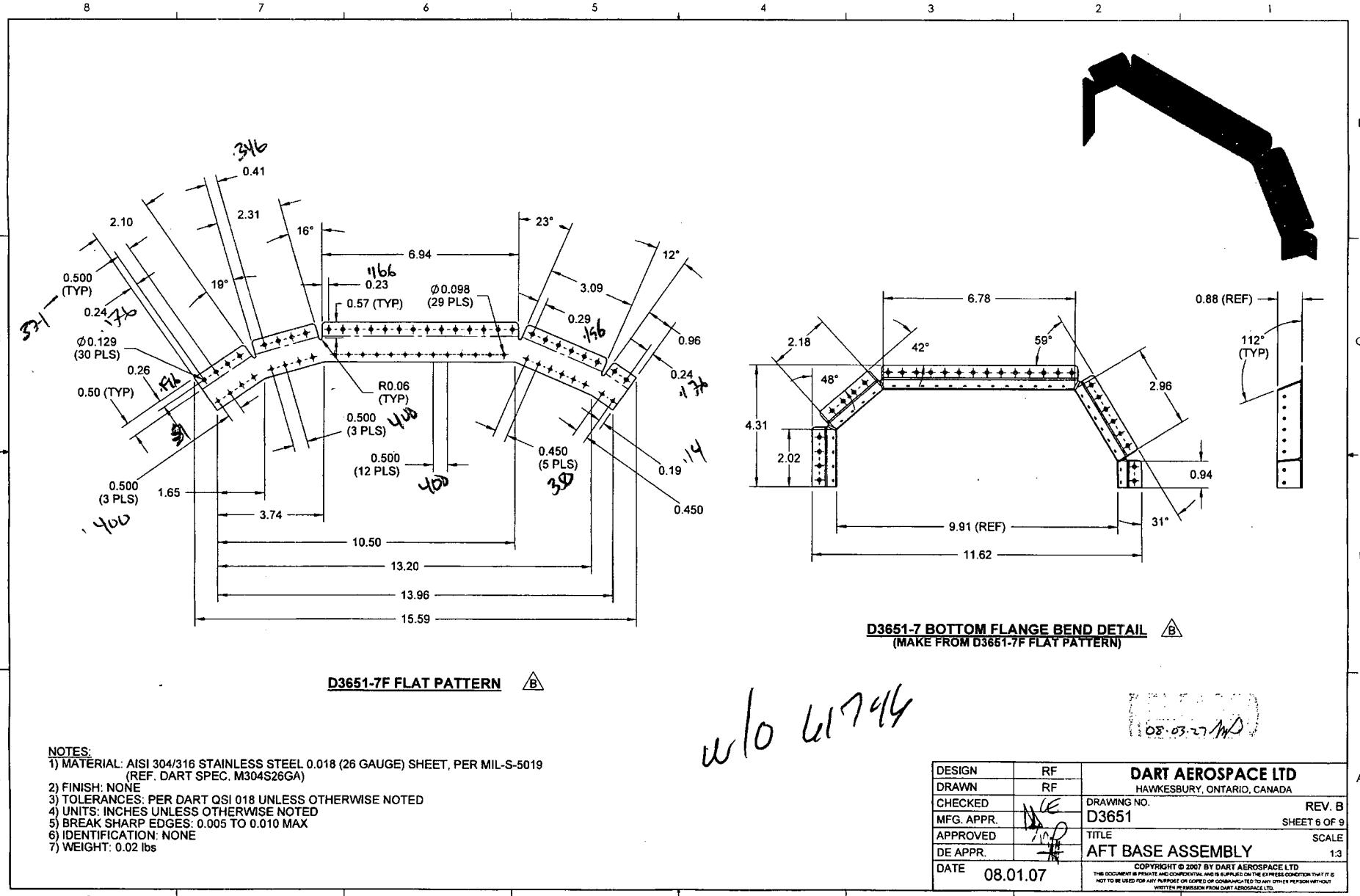
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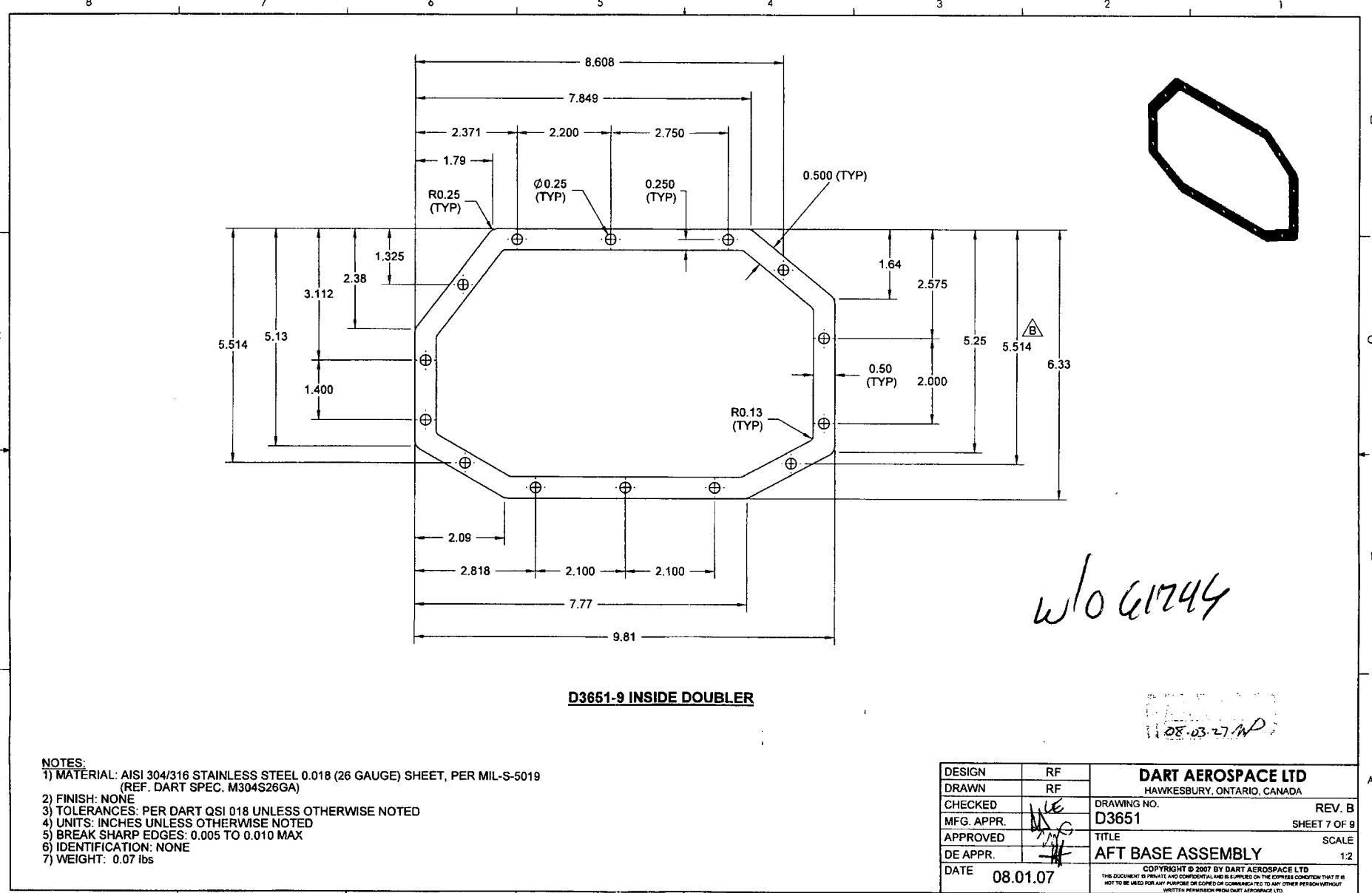
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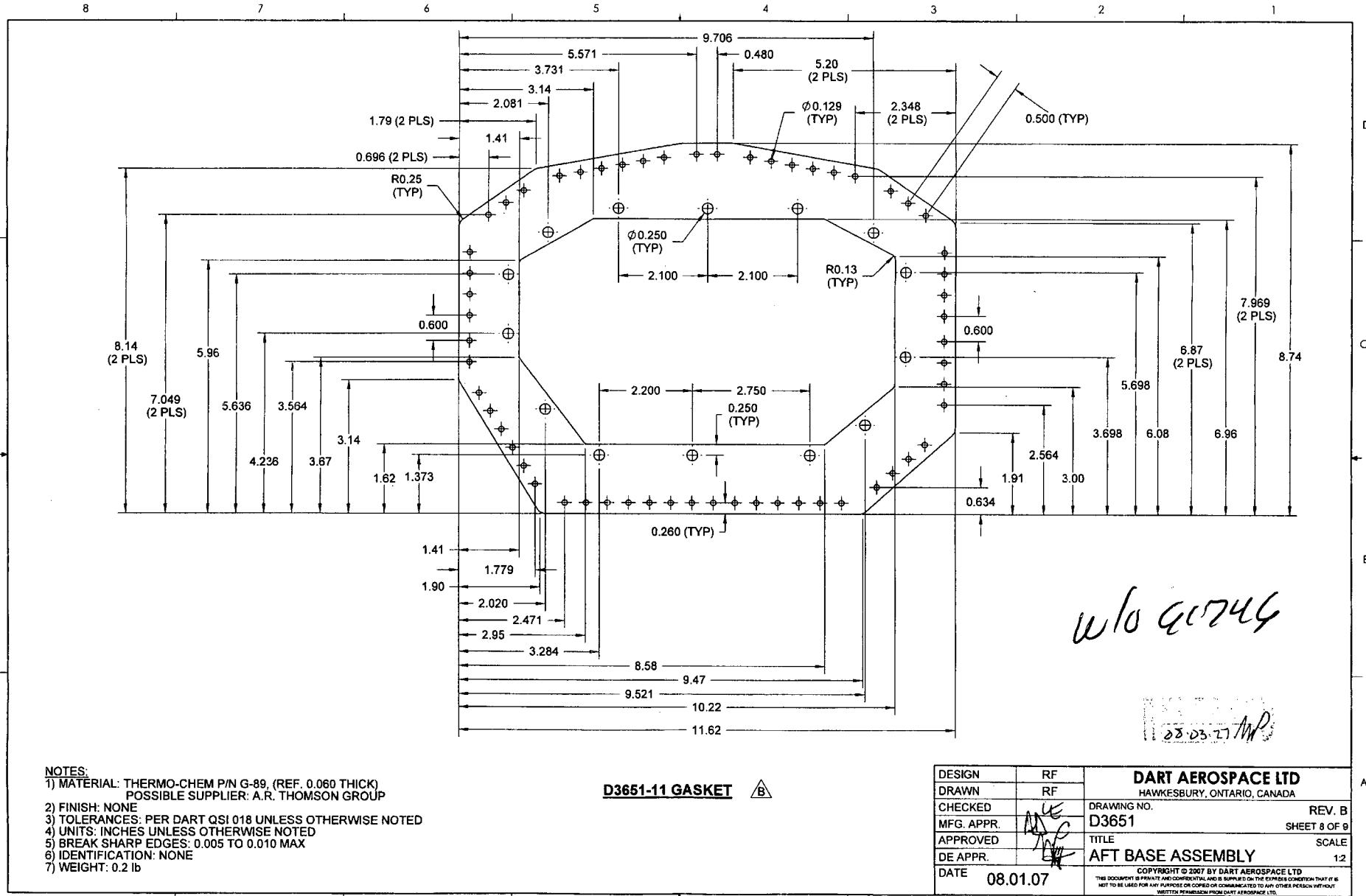
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NOTES:

- NOTES**

 - 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.2 lb

D3651-11 GASKET B

DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>LE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>AN C</i>	D3651	SHEET 8 OF 9	
APPROVED	<i>TAC</i>	TITLE	SCALE	
DE APPR.	<i>W</i>	AFT BASE ASSEMBLY	1:2	
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD		
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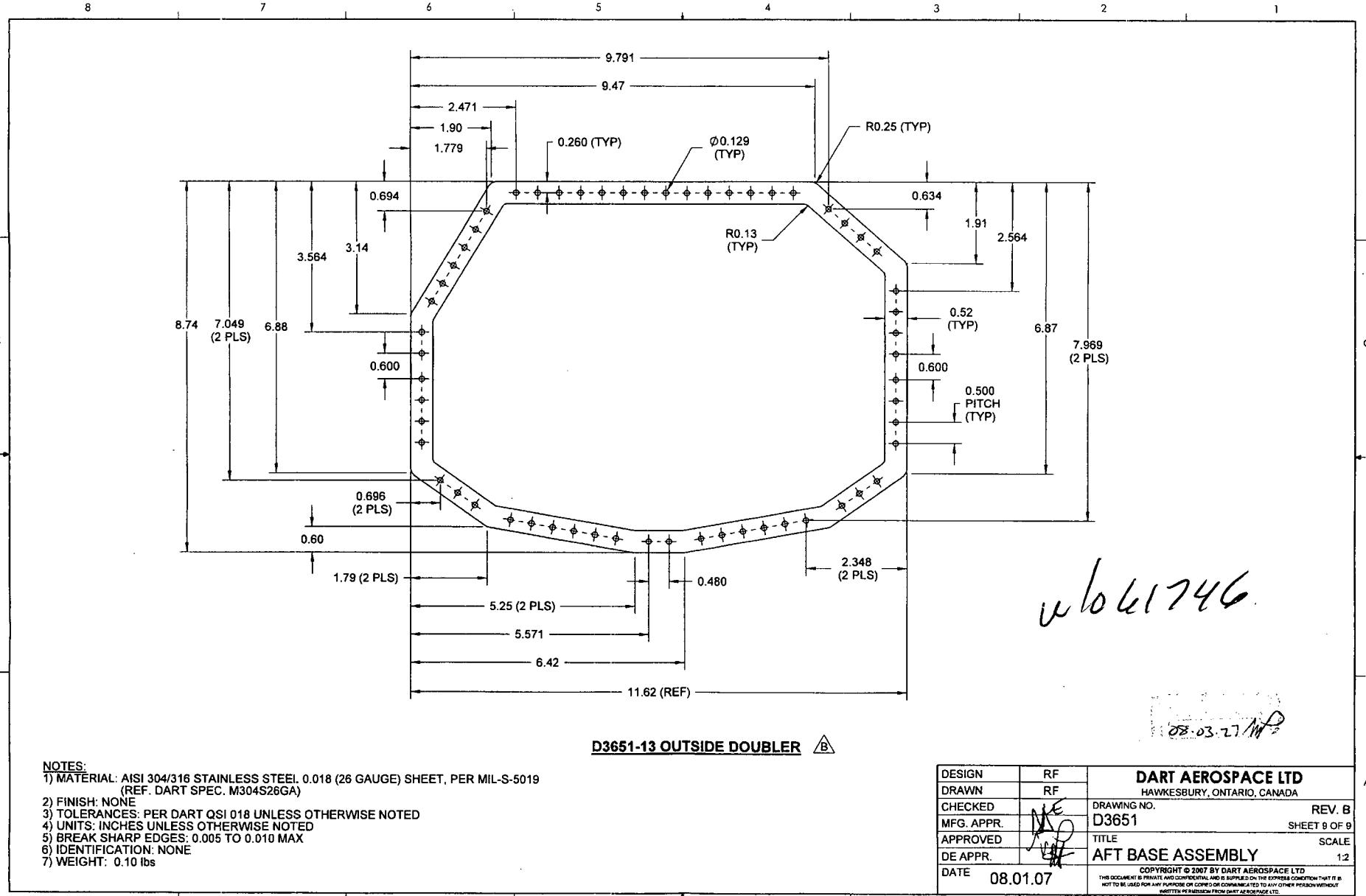
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries